

Date: Friday, 22/05/2009 4:47:45 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE KIT FOR D206-642-512
<b>Job Number</b> : 48172	
<b>Estimate Number</b> : 12894	
<b>P.O. Number</b> :	<b>Part Number</b> : K642 512
<b>This Issue</b> : 22/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : N/A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : N/A
<b>Previous Run</b> : 47885	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 05/06/2009 <b>Qty:</b> 400 Um: Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.05.29</u>	
<b>Comment</b> : Est Rev.A 05.06.07 new issue EC Est. Rev.B 05.02.08, Per ECN1080P	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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**Comment:** Create White labels per PPP K642-512 CHG003

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
Pick Packing Kit

3.0	D206648013	GHW Modification
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D206-648-013 GHW Kit		1548101

9/6/10

SP

4.0	D2652	Bushing
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**Comment:** Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
16 D2652	Bushing	1647649

9/6/15

SP

5.0	D2712	Set Screw
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**Comment:** Qty.: 10.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
10 D2712	Set Screw	165247

9/6/15

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D29322	Saddle RH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

① 47040

3 45263

9/6/4

SP

7.0	D29332	Saddle RH In, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

① 47038

9/6/4

① 45321

② 47968

SP

8.0	D2934	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

① 47947

9/6/5

SP

9.0	D2935	Saddle Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

① 47948

9/6/5

SP

10.0	D29382	Saddle RH Out, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

① 47937

9/6/4

SP

11.0	D29392	Saddle RH In, 206
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

① 47916

9/6/4

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B45667

SP

13.0

D3407043

Tow Ring



3  
47857



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

1  
B44578

9/6/4

SP

14.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

1  
B216752

9/6/5

SP

15.0

D34571

Washer



9/6/5



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

5  
B44793

3  
B44913

SP

16.0

AN3C35A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M109323

SP

17.0

AN3C36A

BOLT



Comment: Qty.: 9.0000 Each(s)/Unit Total : 54.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M110847

9/6/5

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A

BOLT



9/6/4



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M108409

SP

19.0

AN4C6A

Bolt



36  
M111724



Comment: Qty.: 12.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M11295

M109142

M106519

SP

20.0

AN5C11A



9/6/3



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M110847

SP

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M110847

9/6/3

SP

22.0

AN5C13A



9/6/3



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M107800

SP

23.0

AN5C15A



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M109148

9/6/3

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



9/6/3



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M110155

sq

25.0

AN5C34A



9/6/3



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M110342

sq

26.0

AN5C35A



9/6/3



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M107551

sq

27.0

AN960C10L

washer



9/6/3



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M111808

sq

28.0

AN960C416L

WASHER



9/6/3



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M111916

49 M111808

9/6/3

(4x)

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #: Machine Or Operation: Description :

29.0 AN960C516L WASHER



9/6/3



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description Batch  
8 AN960C516L Washer M110139

SP

30.0 MS210433 Nut



9/6/3



Comment: Qty.: 20.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick:

Qty Part Number Description Batch  
20 MS21043-3 Nut M111819

SP

31.0 MS210434 Nut



9/6/3



Comment: Qty.: 13.0000 Each(s)/Unit Total : 78.0000 Each(s)

Pick:

Qty Part Number Description Batch  
13 MS21043-4 Nut M111819

SP

32.0 MS210435 Nut



9/6/3



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch  
4 MS21043-5Nut M11119

SP

33.0 D36721 Phenolic Washer



B547628

9/6/3

SP



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

PHENOLIC WASHER

34.0 D36723 Phenolic Washer



B 47023

9/6/3



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

PHENOLIC WASHER

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 48172

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D36725

Phenolic Washer



B44679



Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s)  
PHENOLIC WASHER

9/6/3

SP

36.0

D36727

Phenolic Washer



B35522



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)  
PHENOLIC WASHER

9/6/3

(4X)

SP

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9/6/11 (A)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-512 CHG003  
Location: PK

9/6/11

(4X)

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/12

Job Completion



11 09.06.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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